

Work Order ID 110020

110020

Page 1

December-17-13 9:06:18 AM

Item ID: D412-742-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: H Date: 12-17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

1100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG005

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Page 2

Item ID: D412-742-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13 Start Qty: 1.00 *1*

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Required Date: 12/17/13 Req'd Qty: 1.00 *1*

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/RSikaflex-241/-291 11127097
Expiry date: 11/08

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 11127097
Expiry date: 11/08

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/RLPS Procyon 11122906

1 x 6 91 14/06/20

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Item ID: D412-742-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible
 Start Date: 12/17/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 05 14-01-21
120									
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00				1		14-1-22	DAS 6 9-89
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14-01-22

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Parent Item: **D412-742-043**

Start Date: 12/17/13

Required Date: 12/17/13

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517
REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No				Each	0.0000					
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	0.0000					
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	0.0000					
AN3C4A Bolt		Purchased	No			110	Each	2,966.0000					
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		20							
				122814		20							
				ST512		44							
				M126765		44							
				ST513		2902							
				125388		1908							
				M127410		994							
AN3C6A Bolt		Purchased	No			110	Each	658.0000					
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		10							
				122416		10							
				FP001		30							
				122599		30							
				ST350		17							
				122416		17							
				ST513		601							
				m125709		601							

Picklist Print

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Work Order ID: 110020
 Parent Item: D412-742-043
 Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13 Required Date: 12/17/13
 Start Qty: 1.00 Required Qty: 1.00

AN3C7A Purchased No 110 Each 910.0000 4 4 12/10/12

Bolt

Location	Loc Qty	Loc Code
FG	10	
122141	10	
ST351	10	
123900	6	
124221	4	
ST513	890	
m125709	890	

NAS1149C0332R Purchased No 110 Each 10,701.000 38 38 12/10/12

WASHER

Location	Loc Qty	Loc Code
FP001	254	
123355	254	
GA	1548	
125654	1548	
ST292	119	
123248	18	
123759	10	
125268	91	
st510	8654	
m126319	3154	
m127306	2500	
m127410	3000	
ST517	126	
124580	126	

D4095-041 Manufactured No 110 Each 12.0000 1 1 12/10/12

Wearplate Assembly

Location	Loc Qty	Loc Code
FP002	12	
108286	2	
109667	10	

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Shop Packet Print

Page 2

Picklist Print

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Parent Item: D412-742-043

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4095-043 Manufactured No 110 Each 3.0000
Wearplate Assembly

1 1 14/01/20

Location	Loc Qty	Loc Code
FP002	3	
106162	2	
<u>109668</u>	1	

1 1 14/01/20

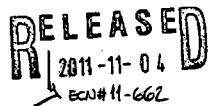
D4095-045 Manufactured No 110 Each 16.0000
Wearplate Assembly

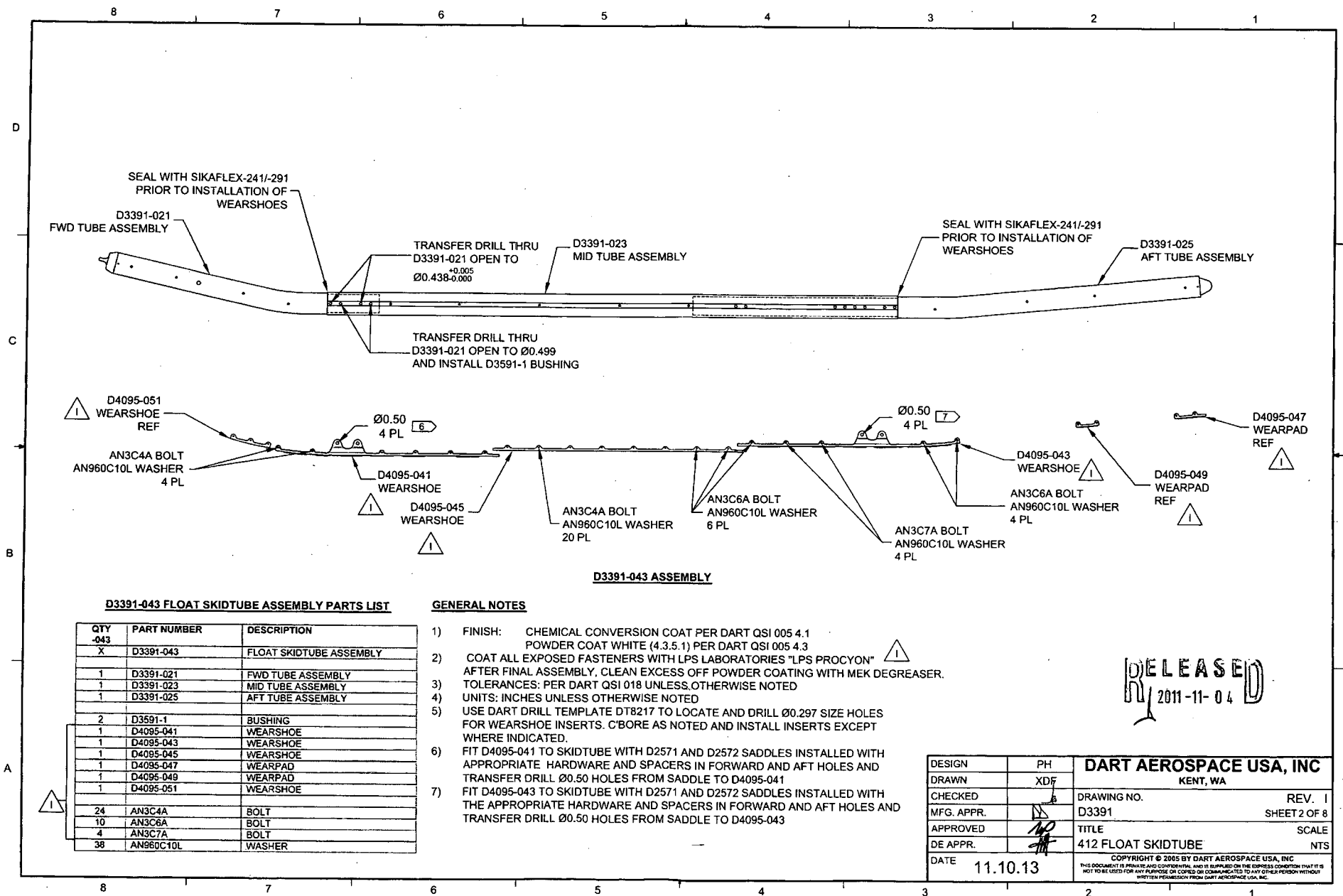
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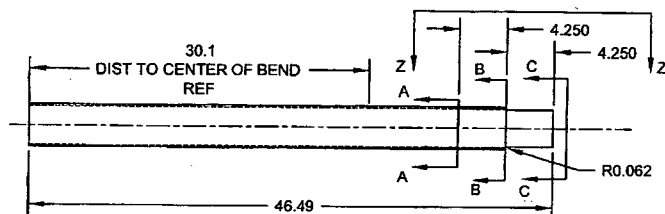
Location	Loc Qty	Loc Code
FP002	16	
108288	1	
<u>109669</u>	11	
77737	1	
84081	1	
93054	2	

1 1 14/01/20

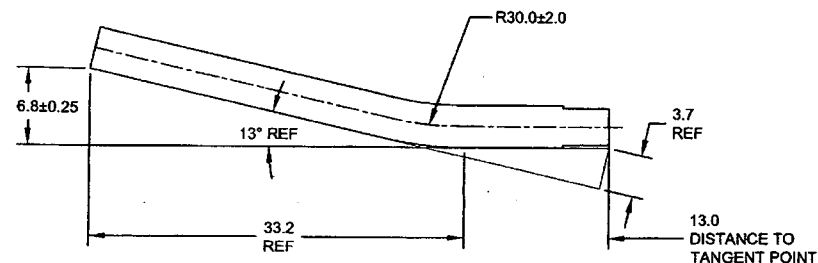
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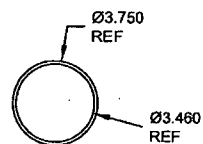




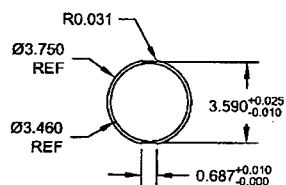
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



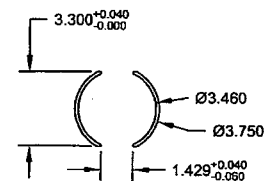
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



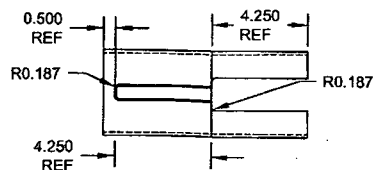
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SECTION B-B
SCALE 2X



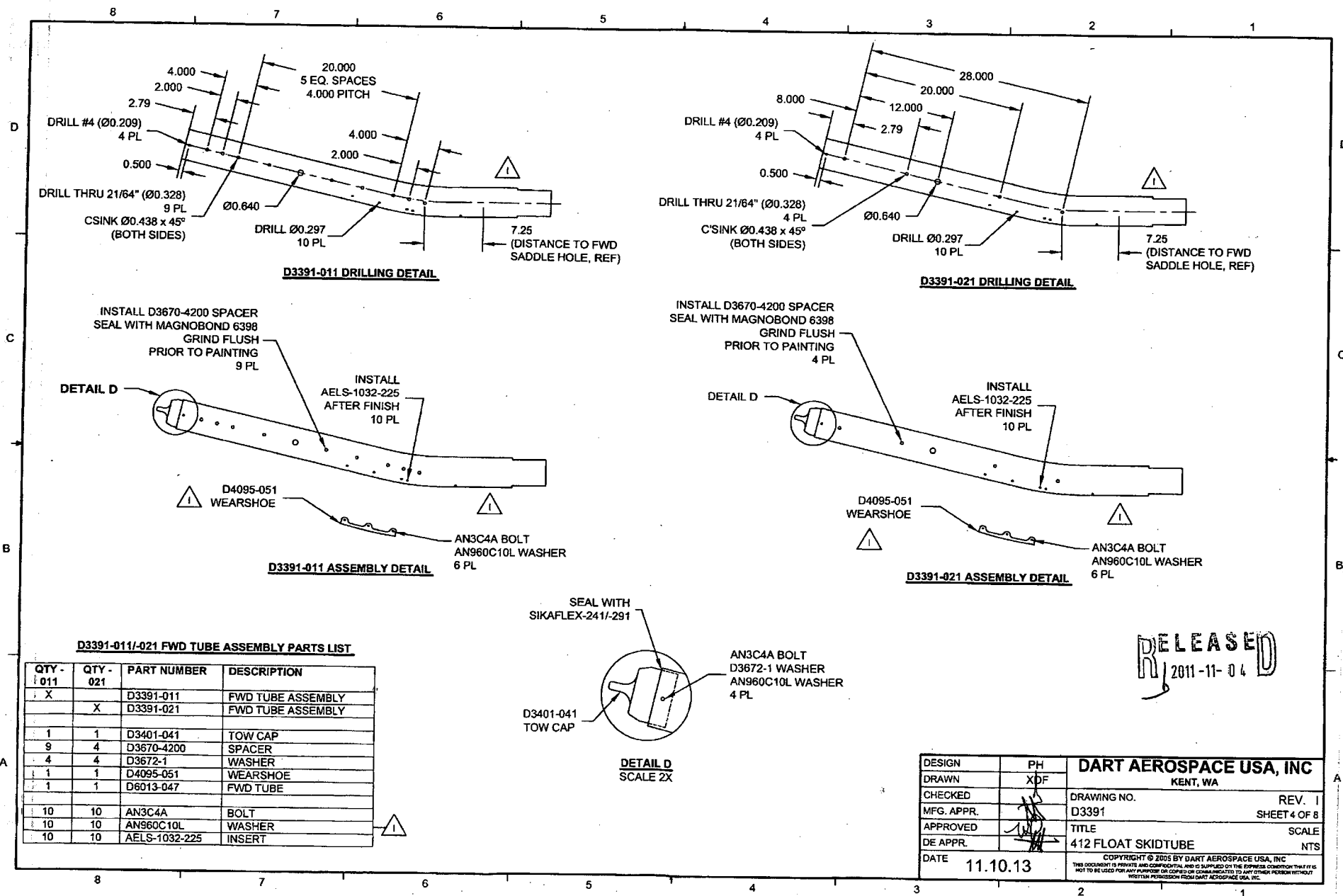
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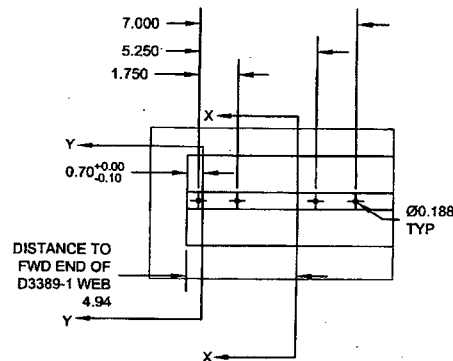


VIEW Z-Z
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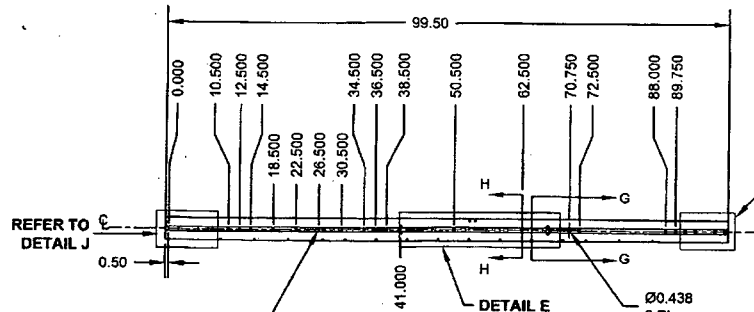
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MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

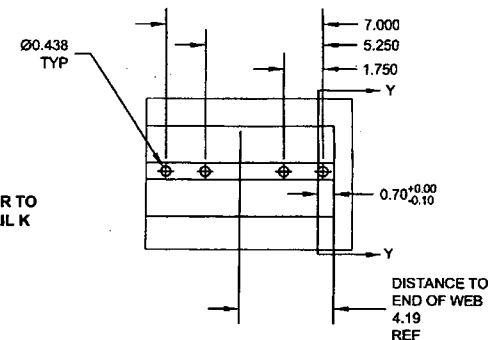




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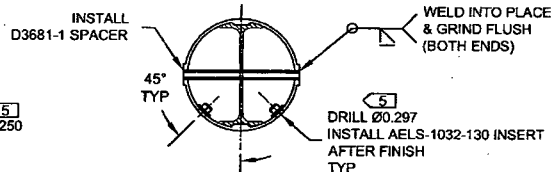
D3391-013 ASSEMBLY DETAIL



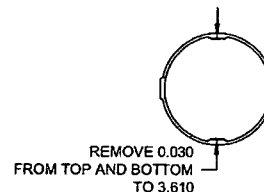
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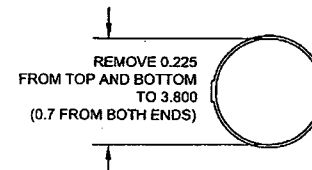
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SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



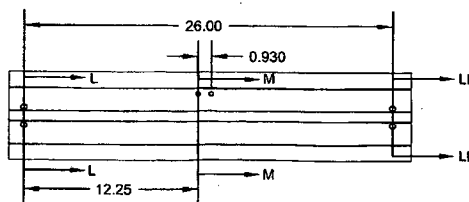
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

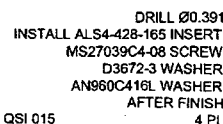
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

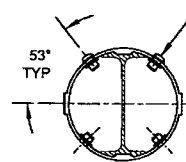
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004



DETAIL E
SCALE NONE

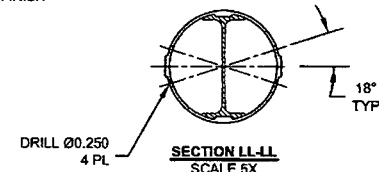


SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X

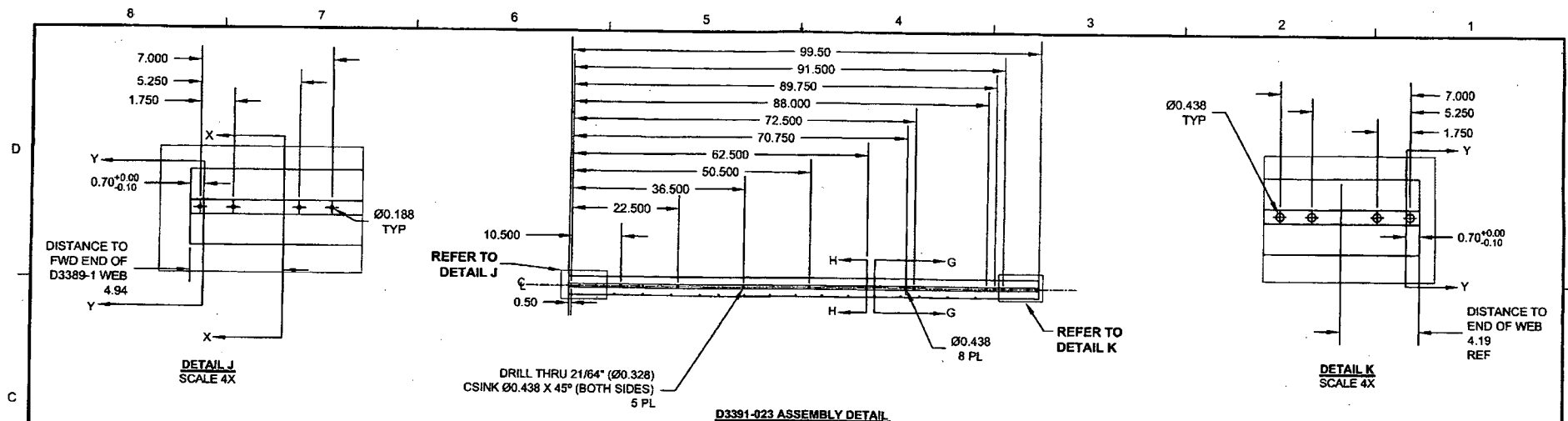
DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



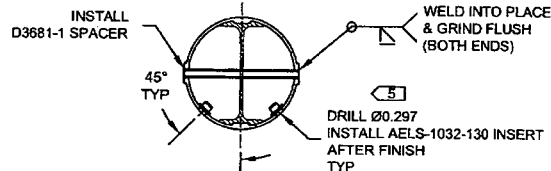
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11-11-04

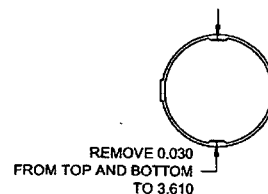
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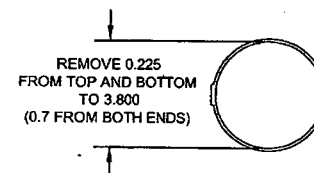
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SECTION H-H
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SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

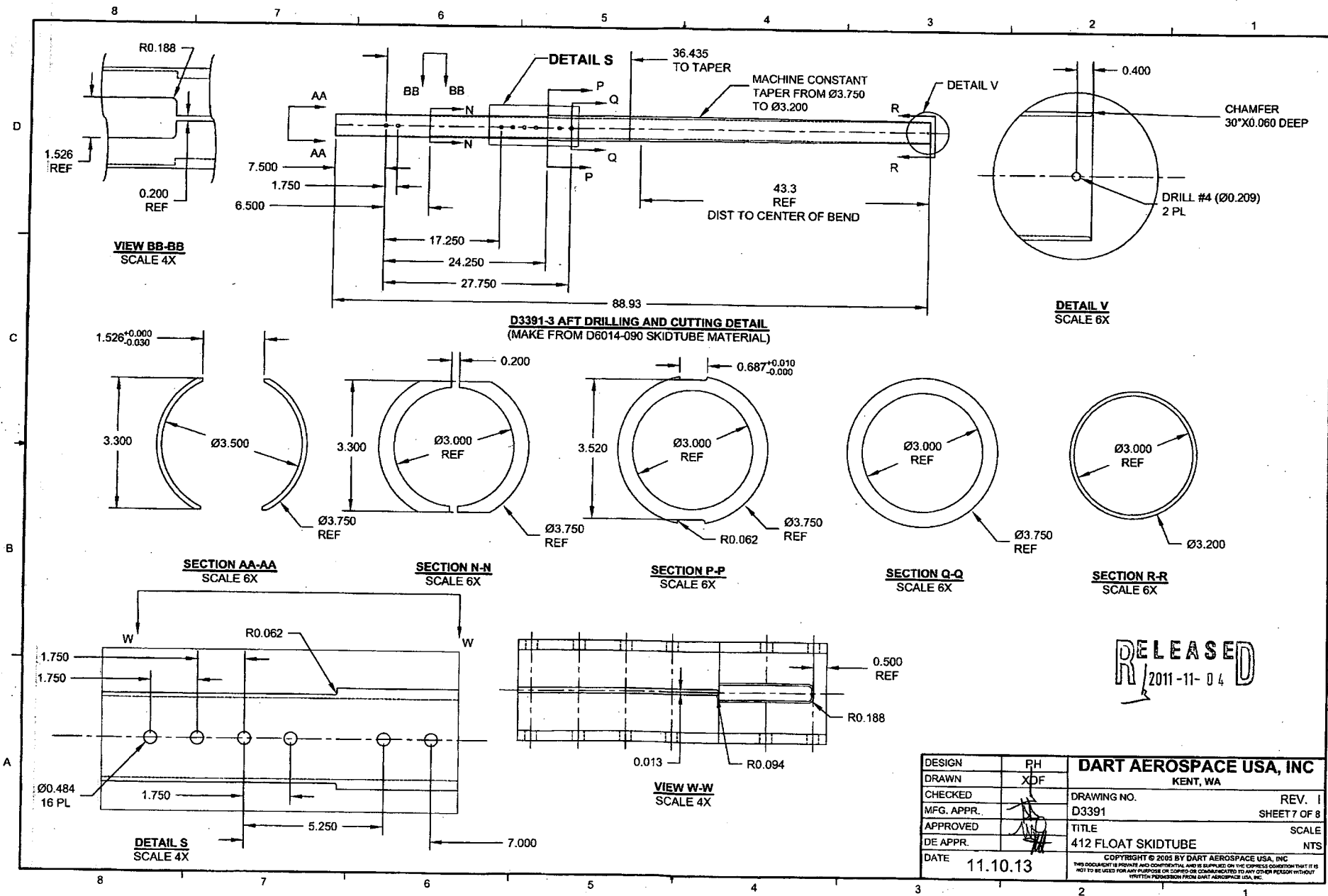
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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2011-11-04

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